

Rush!

Work Order ID 78044

78044

Page 1

Item ID: D4149-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

30

Item Name: Crosstube Lug Plate, Aft

Stop *NS2*

Start Date: 28/12/2011 Start Qty: 8.00

8

Cust Item ID:

Required Date: 12/01/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: M.L.J.

Date: 11/12/12 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4149

C

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D4149

Prog Rev: C

Dwg Rev: C

309.12

Deburr as required

B12-1-2

82

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-1-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78044

78044

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December-28-11 8:12:33 AM

Item ID: D4149-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Crosstube Lug Plate, Aft
 Start Date: 28/12/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 12/01/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				count t32			
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: 8/133 Memo	0.00 0.00							32x Sp 12-01-03.
160 *160* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							ck 12/01/04

12-01-03
62

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

December-28-11 8:12:37 AM

Page 1

Work Order ID: 78044

78044

Parent Item: D4149-1

D4149-1

Parent Item Name: Crosstube Lug Plate, Aft

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 11.03.03 as per revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	61.9000	0.1355	1.141053		4.5	
									**			BID-1-2	

M304S11GA

304/316 0.125 Sheet

Location

Loc Qty

Loc Code

MAT020

61.9

119006

32.5

119048

29.4

119006

32

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 78044
Description: Aft Crosstube Lug Plate		Part Number: D4149-1
Inspection Dwg: D4149	Rev: B <i>12-01-04</i>	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.129	2		✓ BO2	
Ø0.191	+0.005/-0.001	.192	2		✓	
Ø0.257	+0.006/-0.001	.257	1		✓	
Ø0.38	+0.006/-0.001	.379	2		✓	
0.380	+/-0.010	.381	2		✓	
0.469	+/-0.010	.468	2		✓	
0.310	+/-0.010	.310	2		✓	
0.750	+/-0.010	.752	2		✓	
3.25	+/-0.030	3.249	2		✓	
0.65	+/-0.030	.628	2		✓	
0.63	+/-0.030	.627	2		✓	
5.46	+/-0.030	5.457	2		✓	
3.80	+/-0.030	3.801	2		✓	
2.13	+/-0.030	2.118	2		✓	
1.313	+/-0.010	1.308	2		✓	
0.625	+/-0.010	.628	2		✓	
0.375	+/-0.010	.374	2		✓	
1.175	+/-0.010	1.175	1		✓	
0.752	+/-0.010	.756	2		✓	
1.588	+/-0.010	1.588	2		✓	
1.587	+/-0.010	1.586	2		✓	
11.15	+/-0.030	11.155	2		✓ BO2	
0.750	+/-0.010	.762	2		✓	
1.55	+/-0.030	1.560	2		✓	
1.12	+/-0.030	1.126	2		✓	
8.42	+/-0.030	8.42	2		PROWSEN	
2.70	+/-0.030	2.70	2		✓	
0.125	+/-0.010	.118	2		✓	

Measured by: B	Audited by: S	Preliminary Approval:	N/A
Date: 12-1-2	Date: 12/01/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	<i>[Signature]</i>

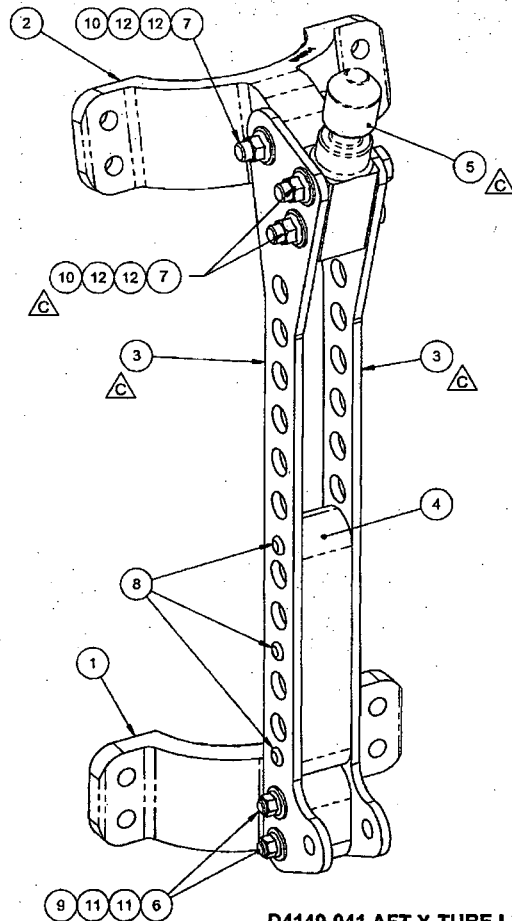
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4149-041 AFT X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.21 lbs

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 SUBJECT TO ASSIGNMENT

WITHOUT NOTICE
 WORK ORDER

NO 78044 M.L.J.
 11/12/28

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4149-041	AFT X-TUBE LUG ASSY
1	1	D3910-1	X-TUBE LUG
2	1	D4091-1	MOUNTING LUG
3	2	D4149-1	AFT X-TUBE LUG PLATE
4	1	D4149-3	SPACER
5	1	D4149-5	EYEBOLT STUD
6	2	AN3C12A	BOLT
7	3	AN4C13A	BOLT
8	3	MS20615-4M18	RIVET
9	2	MS21043C3	NUT
10	3	MS21043C4	NUT
11	4	NAS1149C0332R	WASHER
12	6	NAS1149C0432R	WASHER

C	HOLE DIA CHANGED TO 0.252" (D8-3); HOLE DIA CHANGED TO 0.250" (C8-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1, D7-2)	SC	11.02.22
B	MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); ADDED D4149-5 (SHT 5); D4149-5 WAS D3909-5 (ZN D3-1 & D7-2); REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, C7-1, B7-2 & B3-2); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN DB-3) REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB		
DRAWN	SC		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.02.22		

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4149** REV. C
 SHEET 1 OF 5

TITLE **AFT X-TUBE LUG ASSY** SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

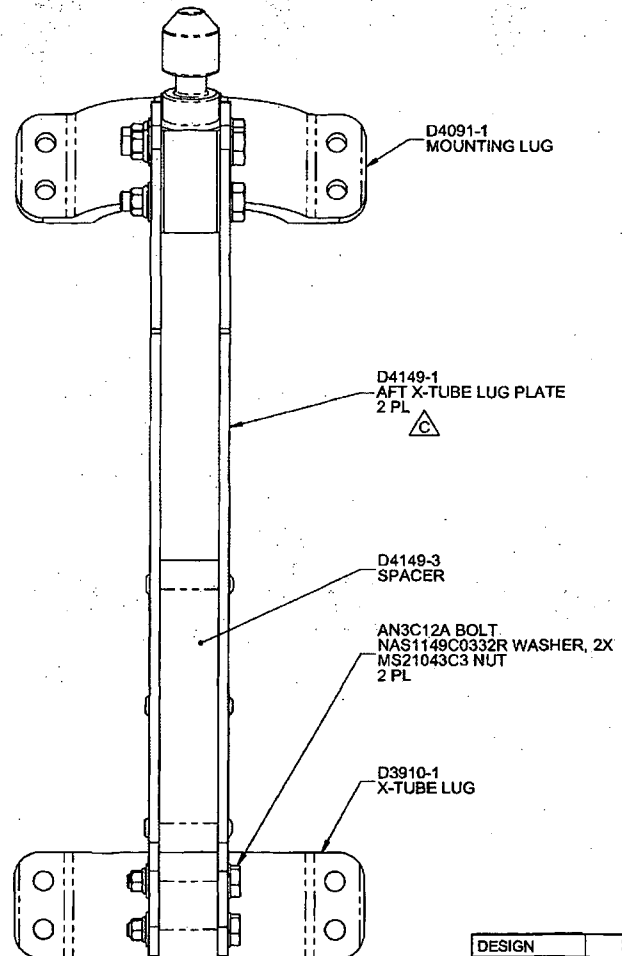
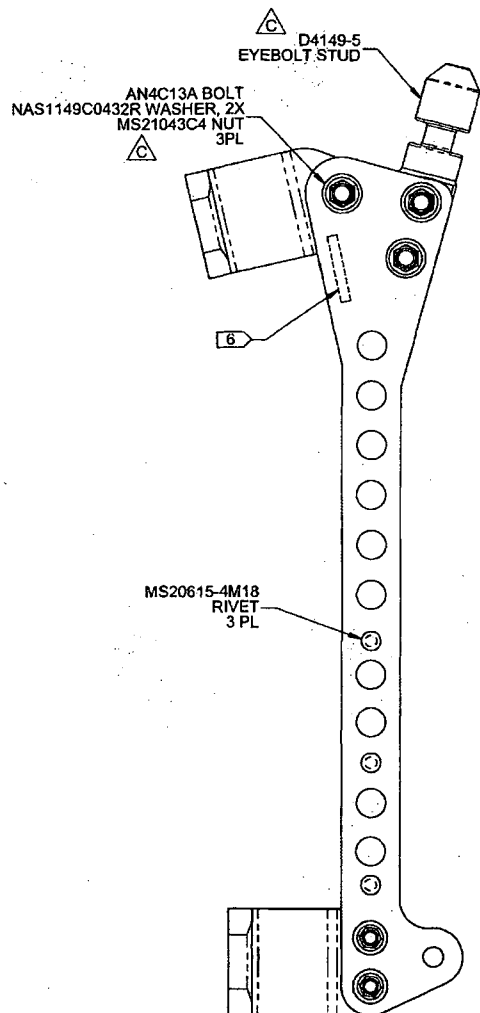
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78044



D4149-041 AFT X-TUBE LUG ASSY

RELEASED
2011-02-24

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
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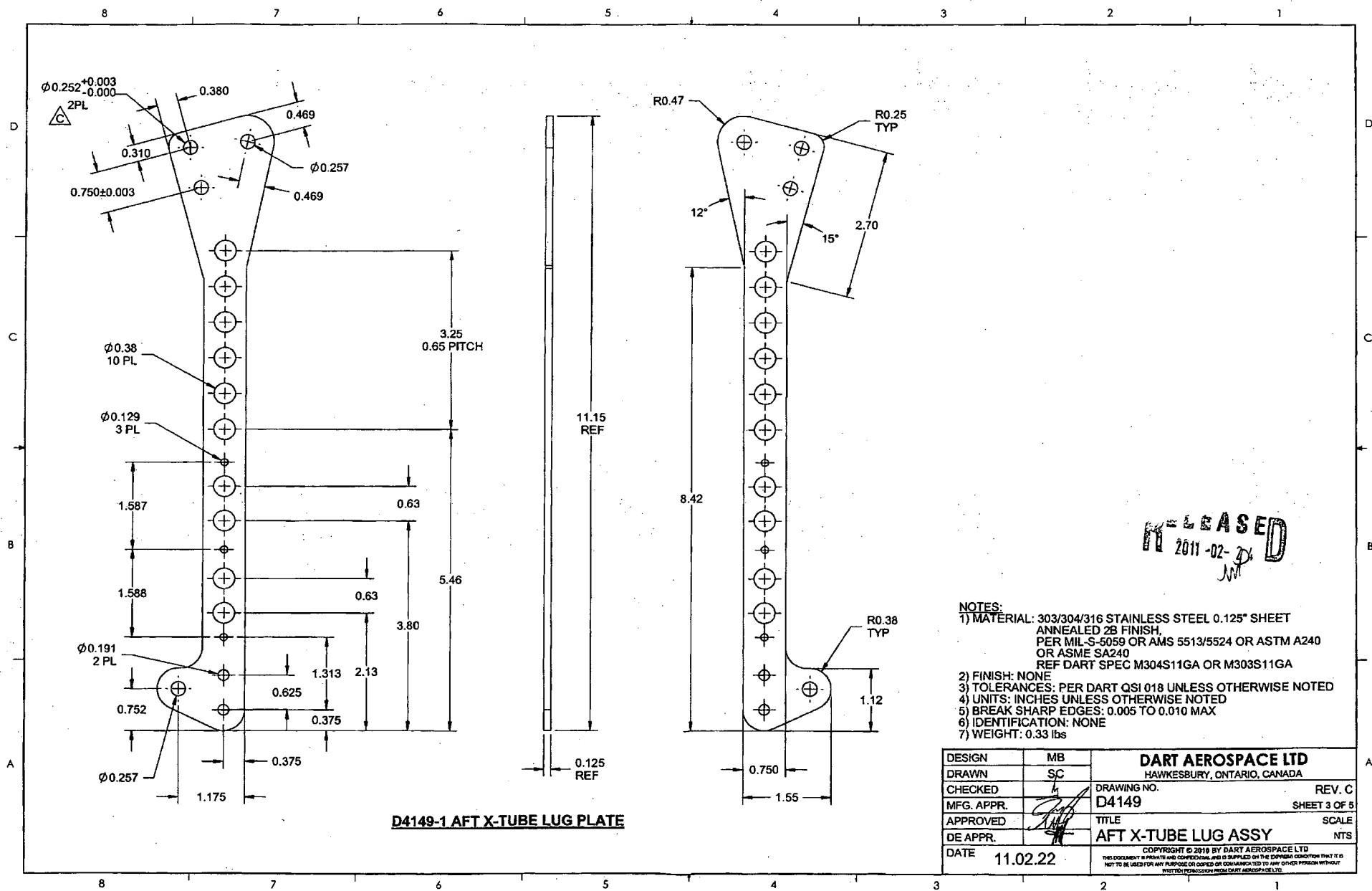
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78044



RELEASED
2011-02-24

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET
ANNEALED 2B FINISH,
PER MIL-S-6059 OR AMS 5513/5524 OR ASTM A240
OR ASME SA240
REF DART SPEC M304S11GA OR M303S11GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.33 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D4149	SHEET 3 OF 5
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

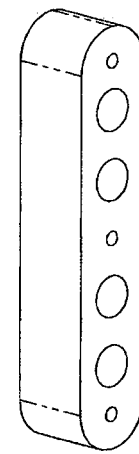
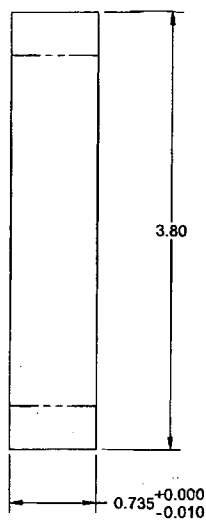
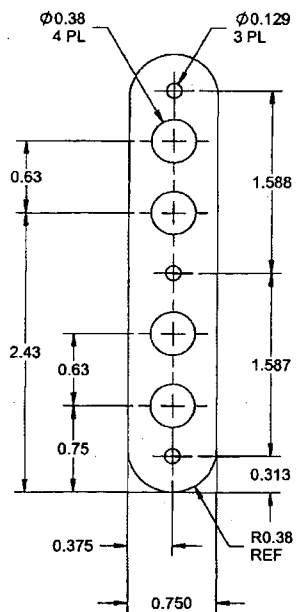
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

78044



D4149-3 SPACER

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.47 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D4149	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
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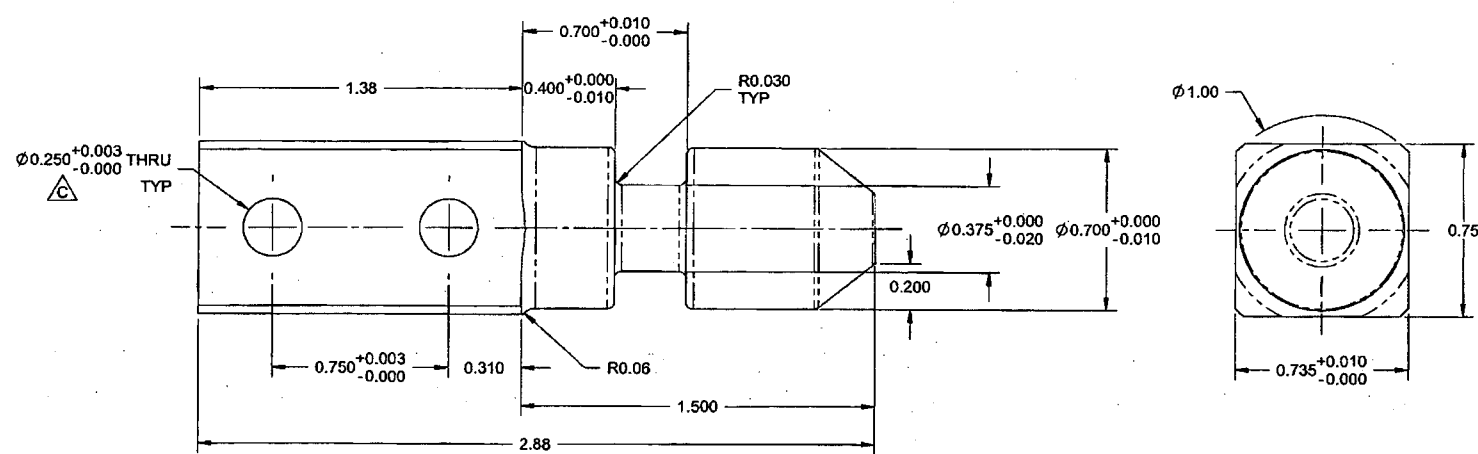
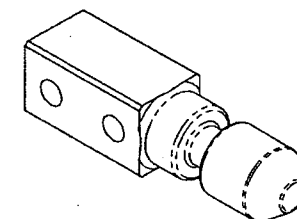
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78044



D4149-5 EYEBOLT STUD

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 5 OF 5
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